

Work Order ID 164327

Tuesday, July 18, 2017, 9:57:58 AM

164327

Page 1

Item ID: D2332-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lid Prop Assembly 6.69"

Start Date: 7/18/2017 Start Qty: ~~500~~

Cust Item ID:

Required Date: 7/25/2017 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 18 2017 Tooling: _____ Date: _____
QC: 9-58 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2332	Rev C1

100

0.00

100

Small Fab

Small Fab

Memo

1.46

1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

7.750

10 ϕ MLL
17-7-24

DAS
19
9-89

110

Punch ends and deburr as per dwg

0.17

110

Brake NC

Brake NC

Memo

0.57

Punch and form D2332-11 to lenght as per dwg D2332 using DT8012
(need 2 per ass'y)

10 ϕ MLL
17-7-24

DAS
19
9-89

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Item ID: D2332-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lid Prop Assembly 6.69"
Start Date: 7/18/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/25/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Small Fab	Memo 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube 3- Deburr	0.00 0.85				10	Ø		mu 17-7-24
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.12				10			DAS 38 9-89 JUL 25 2017
140 *140* Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M136585</u> Memo Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding***** S.S Rod batch: <u>M136585</u>	0.00 0.66				10		DYC 17/07/26	

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Item ID: D2332-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lid Prop Assembly 6.69"

Start Date: 7/18/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/25/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QS1004- Fusion Welds

0.00

150

QC

Memo

0.12

Quality Control

(15)

17-07-27

DAS
9
9-89

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.12

Quality Control

(16)

17-07-27

DAS
9
9-89

170

0.00

170

Small Fab

Memo

0.57

Small Fab

1- Tumble

2- Assemble as per dwg D2332

10

MLC

17-8-1

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Item ID: D2332-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lid Prop Assembly 6.69"
Start Date: 7/18/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/25/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.12				<u>10</u>			DAS 38 9-89 AUG 02 2017
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>51367</u> Memo	0.00 0.06				<u>10</u>		AUG 02 2017	DAS 6 9-89
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.60						DAS 21 9-89 AUG 02 2017	DAS 21 9-89 AUG 02 2017

DAS
21
9-89
AUG 02 2017

Picklist Print

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Work Order ID: 164327

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Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

Start Date: 7/18/2017

Required Date: 7/25/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R.250		Purchased	No			100	f	13.6969	0.1	0.631579			
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M304R 250

304 SS Round bar .250

**

MLL
17-7-24

Location	Loc Qty	Loc Code
MAT028	13.696915	
m133368	2.380915	
m135249	11.316	

0.63

M304TR1.000W.049		Purchased	No			100	f	25.5274	0.43	2.715789			
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M304TR1 000W 049

304 RD Tube 1.00 x .049W

**

MLL
17-7-24

Location	Loc Qty	Loc Code
GA002	25.527449	
125250	25.527449	

2.72

M304TR0.500W.035		Purchased	No			110	f	85.5028	1.25	7.894737			
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M304TR0 500W 035

304 RD Tube .500 x .035W

**

MLL
17-7-24

Location	Loc Qty	Loc Code
GA	85.502796	
3x m137086	14.025477	
m137199	2.300579	
m137286	0.02674	
3x m137415	27.6	
m137623	1.55	
14x m137834	40	

~~0.700~~ 1,182

~~0.00~~

1,182

5,516

Picklist Print

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Work Order ID: 164327

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Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

Start Date: 7/18/2017

Required Date: 7/25/2017

Start Qty: 6.00

Required Qty: 6.00

AN4-4A

Purchased

No

170

Each

23.0000

1

6

AN4-4A

BOLT

**

Location

Loc Qty

Loc Code

over003

20

m137061

20

ST346

3

m137391

2

170

Each

2,296.000

1

6

**

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

11

m135058

11

OVER007

1000

m137988

1000

ST303

1275

m137402

271

m137544

16

m137680

988

170

Each

3,450.000

3

18

**

Location

Loc Qty

Loc Code

GA

610

m131511

610

ST264

2840

m131511

2840

NAS1149D0416J

Purchased

No

NAS1149D0416.I

WASHER

**

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Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge
☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier
				☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing
				☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due
				OTHER : _____			